



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-141
Job Sheet 167074-H



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-14 JSL
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	17/12/18 JSL
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/18 JSL
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	DEC 2 2017
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	2 M.L. 17-12-27
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-1 <u>5021584</u>	1	3	0	0
	- D4636-5 <u>5021588</u>	1	43	0	0
	- D4647-5 <u>5021586</u>	1	2	0	0
	- D4664-5 <u>5021585</u>	6	39	0	0
	- D4712-1 <u>5021583</u>	1	4	0	0
	- D4732-15 <u>5021580</u>	1	2	0	0
	- D4732-19 <u>5021579</u>	1	1	0	0
	- D5021-1 <u>5021578</u>	1	2	0	0
	- MPNY-750S-9-C <u>5021576</u>	7	570	0	0
	- MS20426AD3-4 <u>5021573</u>	4	5,055	0	0
	- MS20426AD4-6 <u>5021571</u>	2	2,797	0	0
	- MS21059L08 <u>5021570</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com S021714 Fwd, Center Ceiling Replacement Panel Assembly D4634 - 141 Start up Operation Mfg Date: 12/14/17 Job No: 167074-H		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"><tr><td style="width: 15%;">Skid-tube ☐</td><td style="width: 15%;">Cross tube ☐</td><td style="width: 15%;">Water Jet ☐</td><td style="width: 15%;">Engineering ☐</td></tr><tr><td>Machining ☐</td><td>Small Fab ☐</td><td>Prod. Eng. Coord. ☐</td><td>Quality ☐</td></tr><tr><td>Forming ☐</td><td>Finishing ☐</td><td>Rec/Store/Packaging ☐</td><td>Other ☐</td></tr><tr><td>Large Fab ☐</td><td>Composite ☐</td><td>Supplier ☐</td><td></td></tr></table> QTY Effective : _____ MRB (QSI042) Approval _____ Disposition Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval					Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Forming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐													
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